

Date: Tuesday, 10/24/2006 10:55:28 AM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LITTER ASSEMBLY
Job Number :	29126		
Estimate Number :	10301		
P.O. Number :	N/A	Part Number :	D2370
This Issue :	10/24/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D2370
First Issue :	N/A	Project Number :	N/A
Previous Run :	28438	Drawing Revision :	B1
	Type :	Material :	N/A
		Due Date :	11/2/2006
Written By :	Qty: 2 Um: Each		
Checked & Approved By :	06/10/24		
Comment :	Est 01.10.10 Changed D2484 nut for D3015-1 SM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue p/o: 2336

C Locel 10/25

(2)

Order: Model 12-2A undrilled with grey pad & black belts

Supplier: Ferno Aviation

Letter of compliance required

2.0

D2370P

Litter Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Litter Assembly

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive and inspect for transit damage

Insure that letter of compliance is attached to w/o

03 06/10/27

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

11/06/14/02

(2)

5.0

D2374

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Stud

Pick:

Qty Part Number

Description

Batch

4

D2374

Stud

26459

✓

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *JD* Date: 06/11/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/02	4.0	1 rivet is loose. from supplier assembly.	<i>JD</i> <i>Q-EN</i>	fast use most conforming Rivet size. Approved by Q.C. PAR 187	↓	<i>JD</i> 06/11/20	<i>JD</i> <i>Q-EN</i>	<i>JD</i> 06/11/02
			<i>JD</i> <i>Q-EN</i>	Take out existing rivet Replace by 1x MS6485 MS830 See PAR 187 Next page.	<i>JD</i> 06/11/03	<i>JD</i> 06/11/07	<i>JD</i> <i>Q-EN</i>	<i>JD</i> 06/11/20

NOTE: Date & initial all entries

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Drawing Name: LITTER ASSEMBLY

Job Number: 29126

Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2378

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	D2378	Mounting Bolt	022015A

✓

7.0

D30151

Lock Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Lock Nut

Pick:

Qty	Part Number	Description	Batch
4	D3015-1	Lock Nut	314710

✓

8.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description	Batch
4	AN960JD416L	Washer	3154

✓

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D2370

2-Drill 0.191" holes as per Dwg D2370

3-Deburr

mul 06/11/03

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/07 (2)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57124 57181

06/14/20 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: 107 Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DD Date: 06/11/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/07	a	2 rivets are base on the stretcher. This is a re-occurring problem	AB 06/11/07	Remove rivets and tap hole $\frac{1}{4}$ -28. Install MS27039-4-06 (B15194) Same as MS27039-4-06 NC17930	FF 06/11/16	DD 06/11/07	AB 06/11/07	06/11/15

NOTE: Date & initial all entries

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Part Number: D2370

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

LG 06/12/21

Job Completion



U 06.11.21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2370	REV. B SHEET 1 OF 2
DATE 98.06.09		TITLE LITTER ASSEMBLY	SCALE NTS
A	95.02.20	NEW ISSUE	
B	98.06.09	ADDED Ø0.191 HOLES	
B1	01.10.10	ADD ALTERNATE FOR D2484	

RELEASED
78/06/15 KE

CP

D2370	Part No.	Description
X	D2370	LITTER ASSEMBLY
1	D2485	LITTER FRAME
2	D2379	RESTRAINT BELTS
4	D2374	STUD
4	D2378	MOUNTING BOLT
1	D2381-1	LITTER PAD
1	D2381-3	LITTER PAD
4	D2484	NUT (<i>OR D3015-1</i>)
4	AN960JD416L	WASHER

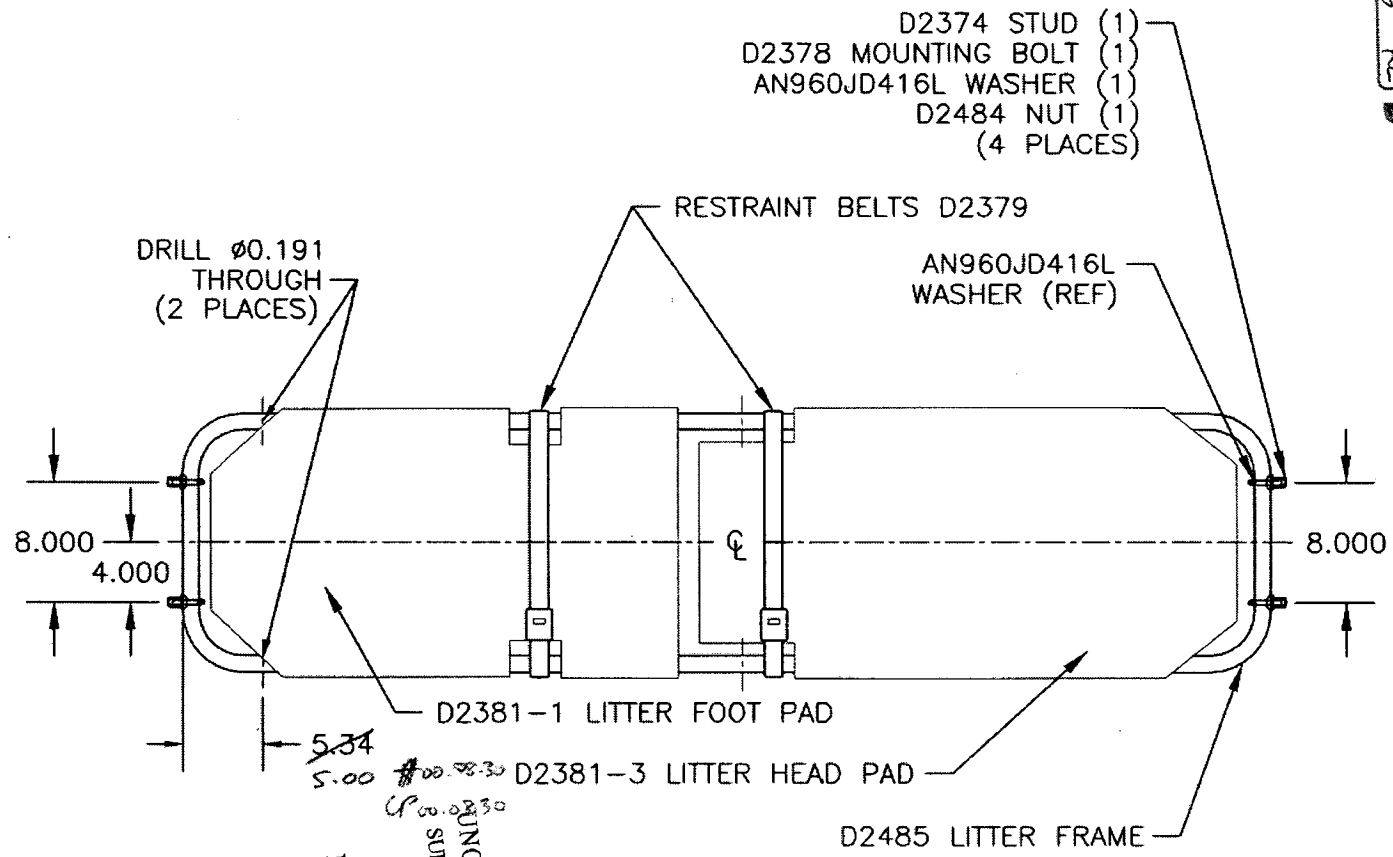
SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *29126*

DART



DESIGN	LE	DRAWN BY	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D2370
DATE	98.06.09	TITLE	LITTER ASSEMBLY	REV. B SHEET 2 OF 2
		SCALE	1:12	

RELEASED
98/06/15 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29126

23 May, 2006

Certificate of Conformance

Manufacturer: Ferno-Washington, Inc.

Manufacturer Address: 70 Weil Way
Wilmington, OH 45177

Country of Origin: U.S.A.

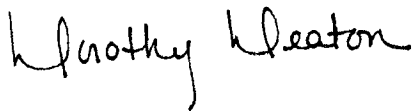
Order No. C-781812

Reference: Dart Aerospace PO # 00002336 ✓ 

Model: 12-2 Stretcher

Serial No. 06-012087, 06-012089

I certify that the above referenced products were produced in accordance with applicable Ferno-Washington engineering standards using approved manufacturing methods and materials. The products have been inspected using approved test procedures and inspection criteria for Ferno-Washington medical devices. The Ferno-Washington Quality Assurance system conforms to US Food and Drug Administration current Quality System Regulation.



Dorothy Deaton
Regulatory Affairs



70 Weil Way ! Wilmington, OH 45177-9371 ! (937) 382-1451 ! FAX (937) 382-1191
Int'l FAX (937) 382-6569
Visit us at our web site: www.ferno.com

23 May, 2006

Certificate of Conformance

Manufacturer: Ferno-Washington, Inc.
Manufacturer's Address: 70 Weil Way
Wilmington, OH 45177-9371
USA
Order No. C-781812
Reference P.O. 3775
Ferno Model No 12-2 Stretcher
Ferno Serial No. 06-012088; 06-012091; 06-012089; 06-012090;
06-012087; 06-012085; 06-012086

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Dorothy Deaton
Regulatory Affairs

Certificate of Analysis

**Client:**

Ohio Foam Corporation
1511 South Alum Creek
Columbus, Ohio 43208

Foam Type: 11032 CFR
Lot Number: 71805
Blue

Fax: 614-252-1213

Test	Methods	Frequency	Requirements	Results
Density (lbs per cubic ft.)	ASTM D3574-03 Test A	Daily	1.05 - 1.15	1.09
IFD (4" 25% lbs/50 sq in.)	ASTM D3574-03 B1	Daily	28 - 38	29.81
Tensile Strength (As rec'd psi) min	ASTM D3574-03 Test E	Monthly	12.0	13.94
Tear Strength (lbs per inch) min	ASTM D3574-03 Test F	Monthly	1.2	1.88
Elongation (% min)	ASTM D3574-03 Test E	Monthly	120%	210%
Flammability	CAL Burn Test (TIB 117)	Daily	PASS	PASS
	MVSS302	Daily	PASS	PASS
Air Flow (1" Thick) min	Q1-104	Daily	3.5	3.56

Authorized Signature

Date:

8-20-05

FLEXIBLE FOAM PRODUCTS, INC.

200 East North St., P.O. Box 124
Spencer, OH 43887
Ph. (419) 647-4172 Fax (419) 647-6720



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23 May, 2006

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Tear Strength (lbs per inch) min	ASTM D3574-03 Test F	Monthly	1.2	1.68
Elongation (% min)	ASTM D3574-03 Test E	Monthly	120%	210%
Flammability	CAL Burn Test (TIB 117)	Daily	PASS	PASS
	MVSS302	Daily	PASS	PASS
Air Flow (1" Thick) min	Q1-104	Daily	3.5	3.56

Authorized Signature: 

Date:

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